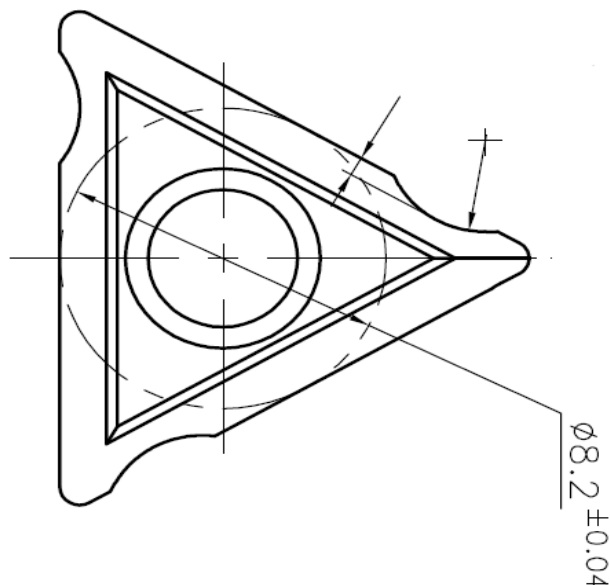
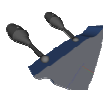







## Insert TXET12M3 ID-Ø8.2 R2.5

A08-010



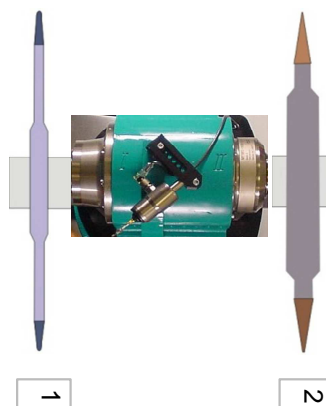
### 1. Cycletime for Production

Workpiece:	Triang Ref ID-Ø8.2,T3.0			
Material	CARBIDE			
Operations				
Feed [mm/Min]	2000	30	30	9000
Power [kW]		3	2	1
Cutting speed [m/s]		20	22	
Used wheels				
Grinding time [s]	26	75	75	15
Total cycle time	3 Min 12			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14EE1 Ø300 D76V20°
2	14EE1 Ø300 D46V20°



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 310i

Accessories: Loader STL6050, TTC clamping

Responsible engineer: OP, 29.8.14

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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